

Work Order ID 52232

Monday, September 21, 2009 11:42:03 AM



Page 1

Item ID: D206-559-011

Revision ID: E1

Item Name: Bearpaw

Start Date: 9/22/2009 Start Qty: 4.00

Required Date: 10/6/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: PLDate: 09-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPPD206-559-011 CHG006

8/21/24

HG for BG 09/11/03

160

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

9/11/03 (405)

170

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8/21/24

(44)

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Start Date: 9/22/2009 Start Qty: 4.00

Required Date: 10/6/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-011 □ Location: <u>11A</u>								
		REUB							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/11/24 sf (4) sf
09/11/25 J
PK 09-11-24 (4)

Picklist Print

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Monday, September 21, 2009 11:42:02 AM

Work Order ID: 52232



Parent Item: D206-559-011RevE1



Parent Item Name: Bearpaw

Start Date: 9/22/2009

Required Date: 10/6/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

QS200-M44S

42

Purchased

No

120

Each

3.0000

8.0000



Clamp

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

107035

3

170

Each

616.0000

32.0000

AN4-15A

68

Purchased

No



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

616

107737

8

108077

1

108868

7

109148

18

110399

8

111295

574

112599

sf

111295

9/10/09 QW sf

Picklist Print

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Parent Item Name: Bearpaw

Start Date: 9/22/2009

Required Date: 10/6/2009

Comments:

Start Qty: 4.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			170	Each	2,068.000	32.0000			



Bolt



9/10/19 @ 50 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2068

105653

5

107321

58

109061

5

111758

1000

112314

1000

SP
111758

Picklist Print

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Parent Item Name: Bearpaw

Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	x16	Purchased	No			170	Each	7,829.000	64.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7829	
102929	2	
105906	4	
106277	2	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	101	
111916	1995	
112314	4595	
16941	0	

112314 SP

D2182BRevC

Manufactured No

170 f 228.2300 6.6640

Rubber Cushion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	228.23	
28042	7.33	
30872	0.33	
45405	220.57	

Cut (4) at 5.00" pending
per kit

(D2182 B050) 9/10/19

9/10/19 (45)

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Shop Packet Print

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Picklist Print

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Parent Item Name: Bearpaw

Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2274RevF Radius Block	x8	Manufactured	No			170	Each	624.0000	32.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	624
22494	0
23174	0
36624	17
38173	6
42099	34
43838	62
47796	32
50227	149
51425	324

D2435RevE1

x2

Manufactured No

170

Each

0.0000

8.0000

Bearpaw, 206

D2438RevC

x4

Manufactured No

170

Each

53.0000

16.0000

Clamp

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	53
46113	53

51425 9/10/19 (4)

B53431 / C9111/24 (8)

B52098 / C9111/03 (4)

Picklist Print

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Parent Item Name: Bearpaw

Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2529RevE	KS	Manufactured	No			170	Each	470.0000	32.0000			



Washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

470

51406

470

51406 SP

MS21042L4

Purchased

No

170

Each

7,906.000

32.0000



Nut

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7906

107499

5

108145

4

110450

1

110507

184

111827

5996

112314

1651

15924

0

7690

24

8182

41

111827 9/10/19 CW SP

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE DEOS

9143	

SHOP COPY

RETURN TO

ENGINEERING

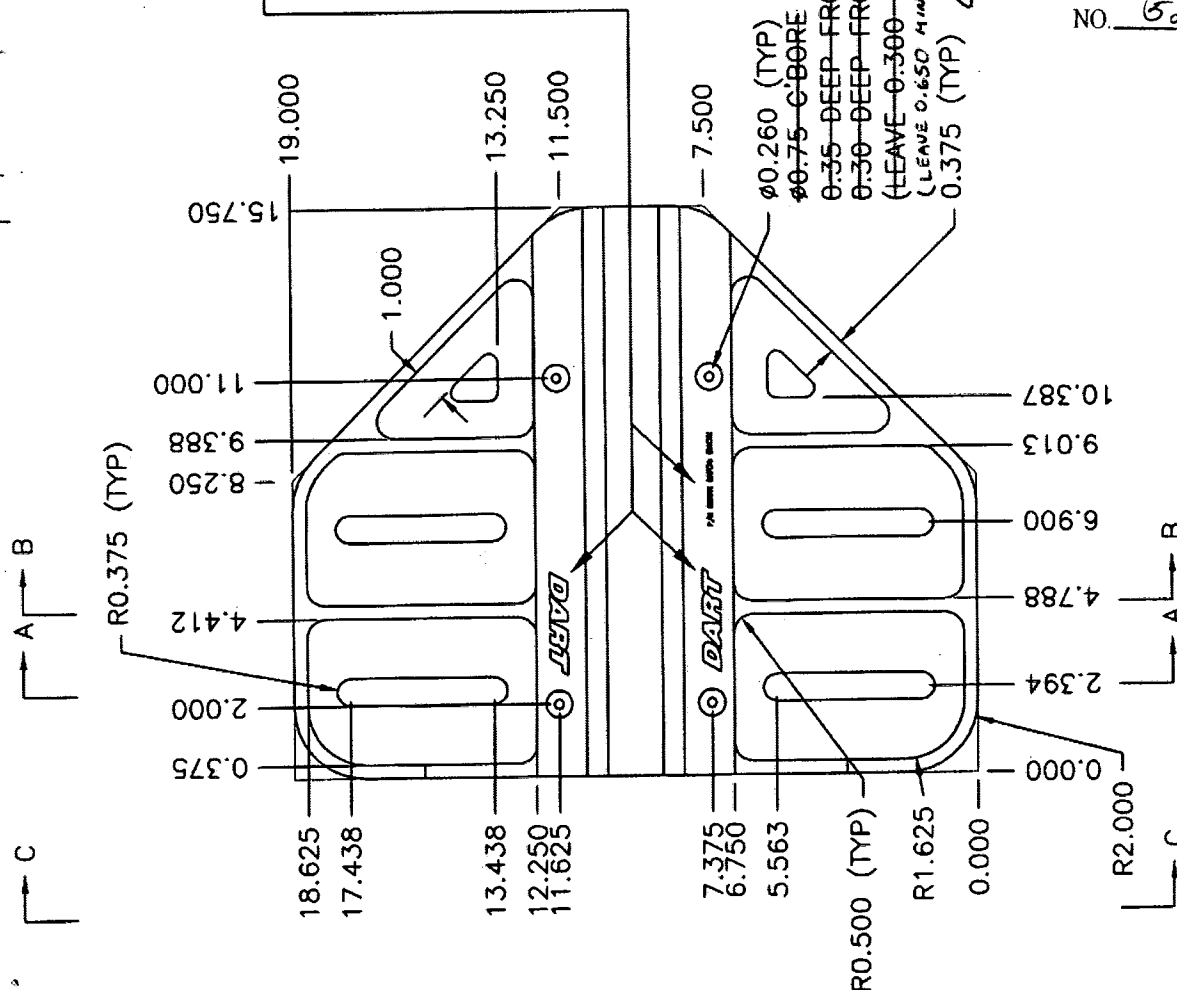
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 62232

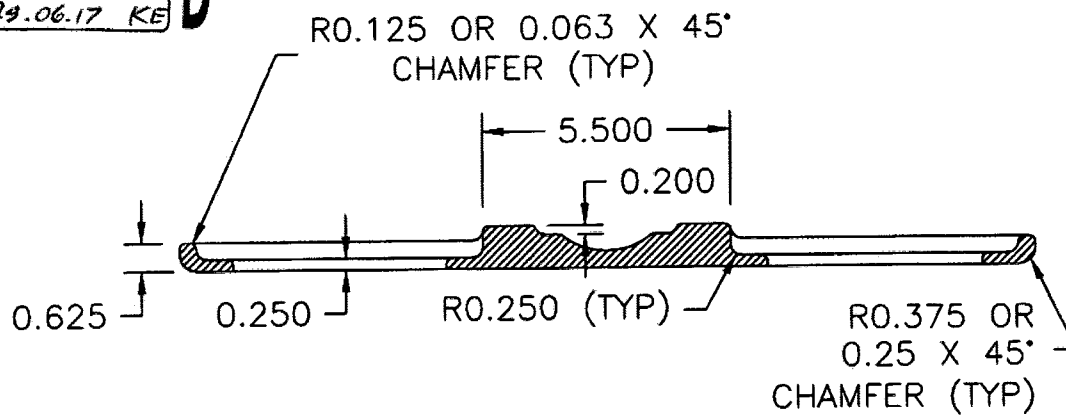


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

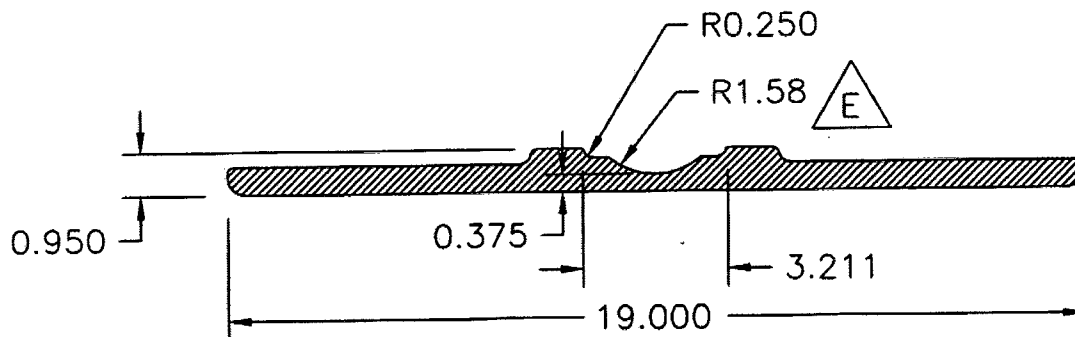


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DJB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

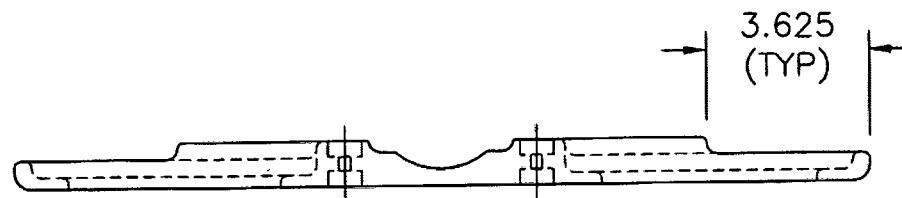
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-15A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER
2		2					QS200M44S	CLAMP

52232